

Endmill Ø25 Z8

A01-010

The material removal for reshaping is 0.05 to 0.1 mm at the cutting face and O.D. and 0.3 mm at the end. The tool is ground with a small nearly cyl. land as primary clearance on O.D. A chamfer operation is breaking the sharp edges of end with a 0.2 mm and 45° chamfer.



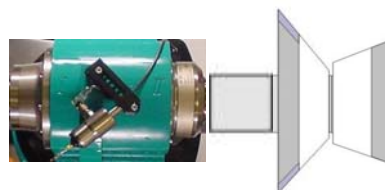
1. Cycletime for Reshaping

Workpiece: Ø 25 mm, Z 8, Length 45 mm, Helix 47°, prim.Land 0.02 - 0.05 Material CARBIDE								
Operations	Probe	Flute 1	Gashing	O.D.3	O.D.2	O.D.1	End 1	Chamfer
Feed [mm/Min]	2000	300	100	250	300	400	120	400
Power [kW]		3	2	1	1	2	1	1
Cutting feed [m/s]		32	32	32	32	32	32	24
Used wheels		1	1	2	2	2	2	2
Grinding time [s]	29	170	130	163	141	121	102	41
Total cycle time	14 Min 56							

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	12V9 Ø125 D64
2	11V9 Ø100 D64



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3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR Coolant: Synthetic Oil, pressure 6 bar
 Control: Fanuc 160i/310i Software: Quinto 5
 Accessories:

Responsible engineer: OP. 27.10.10

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